

Work Order ID 134099

Tuesday, June 30, 2015 9:09:28 AM

134099

Page 1

Item ID: D5208-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Guide
 Start Date: 6/30/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 7/03/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan:  Date: 6-6-30 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5208	B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

(12)

06/15/06/30

(12)

06/15/06/30

(12)

15-06-30

DAS
9
9-89

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Item ID: D5208-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Guide
 Start Date: 6/30/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 7/03/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00			DAS 30 9-89	12			JUN 30 2015
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(12)			DAS 38 9-89 JUL 02 2015
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00			DAS 30 9-89	12			JUL 02 2015 JUN 30 2015

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Item ID: D5208-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Guide

Start Date: 6/30/15

Start Qty: 12.00

12

Cust Item ID:

Required Date: 7/03/15

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

ML5

JUL 03 2015

ML5

JUL 02 2015

Picklist Print

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Work Order ID: 134099

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Parent Item: D5208-3

D5208-3

Parent Item Name: Guide

Start Date: 6/30/15

Required Date: 7/03/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 15.01.29 NEW ISSUE DD VERF:JLM IPP
REV:B 15.05.28 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S24GA

Purchased

No

sf

28.1000

1

M304S24GA

304/316 .025 Sheet

**

06/15/06/20

Location

Loc Qty

Loc Code

MAT020

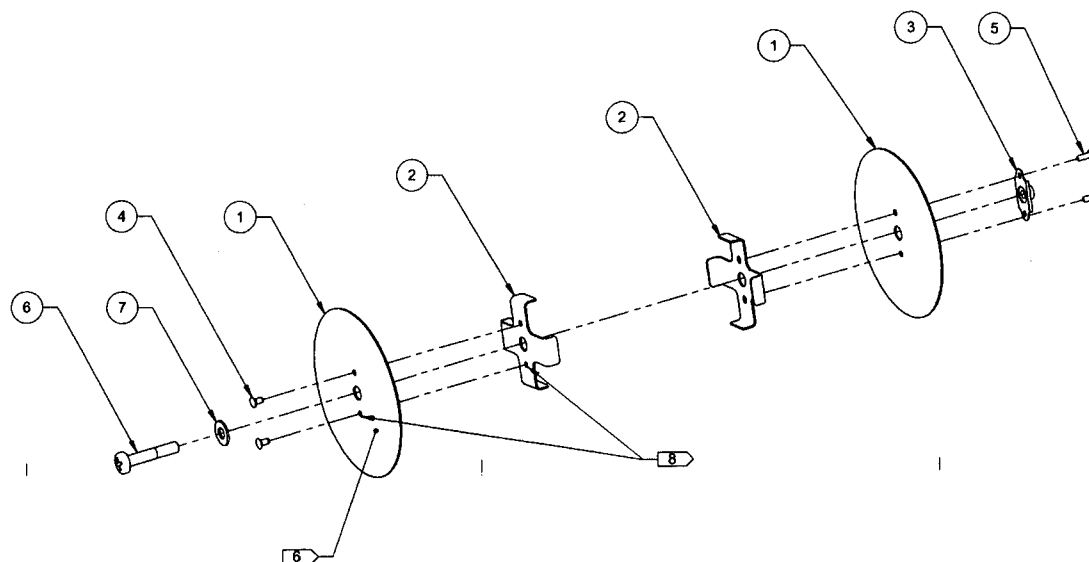
28.1

131723

28.1

.6

ITEM	QTY	P/N	DESCRIPTION
	X	D5208-041	BLANKING PLATE ASSY
1	2	D5208-1	BLANKING PLATE
2	2	D5208-3	GUIDE
3	1	FM5001-050	ANCHOR NUT, FLOATING
4	2	MS20427M3-3	RIVET, SOLID, CSK
5	2	MS20615-3M3	RIVET, SOLID, PAN-HEAD
6	1	LN9038-05-26	SCREW, PAN-HEAD
7	1	BS4320-A5	WASHER (ALT: BS4320-A-5, BS4320-AM5, NAS1149C0332R)



D5208-041 BLANKING PLATE ASSY

RELEASED

A7 2015 JUN 22 *EN 15-589*

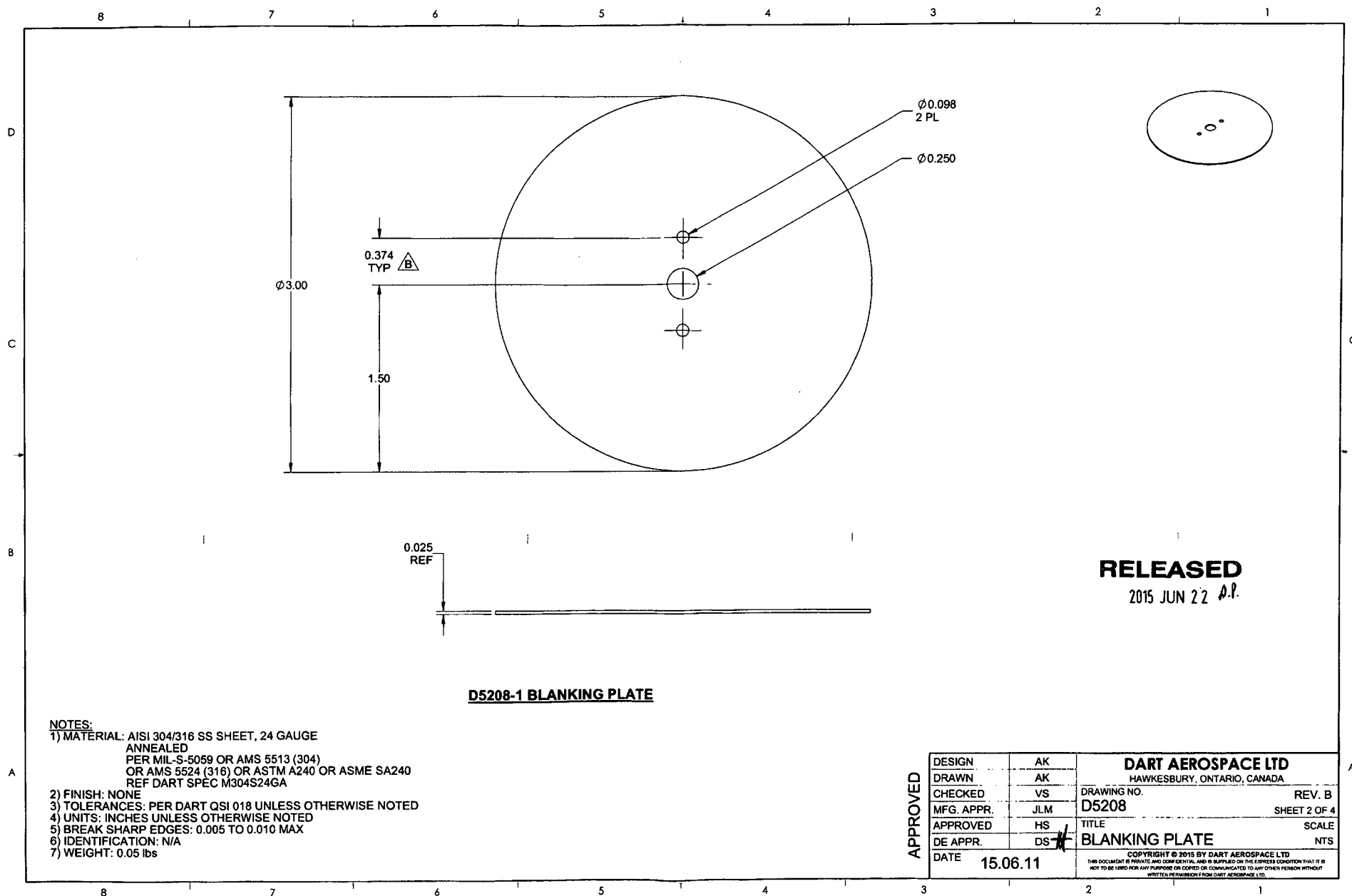
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs
- 8) DIMPLE THIS FACE OF D5208-1/-3 PRIOR TO INSTALLING RIVETS

Handwritten: 15630
134099

APPROVED

DESIGN	AK	DATE	15.06.11
DRAWN	AK	DATE	15.01.13
CHECKED	VS	DATE	
MFG. APPR.	JLM	DATE	
APPROVED	HS	DATE	
DE APPR.	DS	DATE	
DESCRIPTION		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.		REV. B	
D5208		SHEET 1 OF 4	
TITLE		SCALE	
BLANKING PLATE		NTS	
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2015 JUN 22 *AP*

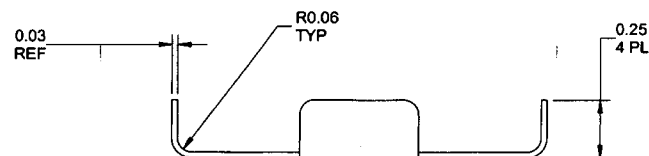
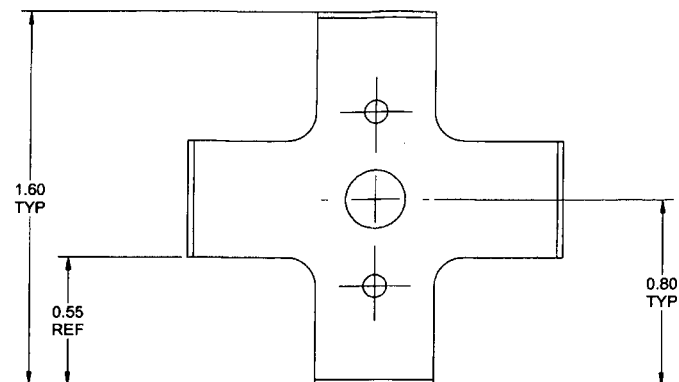
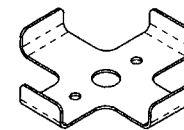
D5208-1 BLANKING PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 24 GAUGE
ANNEALED
PER MIL-S-5059 OR AMS 5513 (304)
OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S24GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

APPROVED

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DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5208	SHEET 2 OF 4
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D5208-3 GUIDE

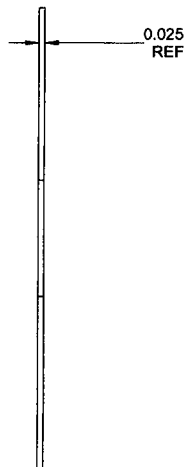
RELEASED
2015 JUN 22 49

NOTES:

- 1) MATERIAL: MAKE FROM D5208-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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2015 JUN 22 A.P.

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ANNEALED
PER MIL-S-5059 OR AMS 5513 (304)
OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S24GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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	DRAWN	AK		SHEET 4 OF 4
	CHECKED	VS		SCALE
	MFG. APPR.	JLM		NTS
	APPROVED	HS		
	DE APPR.	DS		
	DATE	15.06.11		